

# Work Order ID 85776

Tuesday, July 03, 2012 1:50:40 PM

**\*85776\***

*DUPLICATE*

Page 1

Item ID: D4016-3

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Hinge Half, Lid

Stop **\*NS2\***

Start Date: 6/15/2012 Start Qty: 18.00

**\*18\***

Cust Item ID:

Required Date: 6/21/2012 Req'd Qty: 18.00

**\*18\***

Customer:

Reference:

Approvals:

Process Plan: *MUF*

Date: *12-07-03*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4016	A

100	Cut blanks as per folio	0.00
-----	-------------------------	------

**\*100\***

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK as per folio

*OK 12/07/03*

*18*

110

0.00

**\*110\***

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG

FOLIO REV: *44*

DWG REV: *4*

DEBURR

*OK 12/07/04*

*18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

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Page 2

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**\*18\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*OK 12/07/04*

*18*

*9*

130

QC8- Inspect parts - second check

0.00

**\*130\***

QC

Memo

0.00

Quality Control

*SL 12-07-04*

*18*

160

Identify as per dwg & Stock Location: *WA*

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

*18*

*12/07/04 JB*

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**Work Order ID 85776****\*85776\***

Page 3

Tuesday, July 03, 2012 1:50:40 PM

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**\*N900040100\***Setup Start **\*NS1\***

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Item Name: Hinge Half, Lid

Stop **\*NS2\***

Start Date: 6/15/2012 Start Qty: 18.00

**\*18\***

Cust Item ID:

Required Date: 6/21/2012 Req'd Qty: 18.00

**\*18\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC21- Final Inspection - Work Order Release

0.00


**\*170\***

QC

Memo

0.00

Quality Control

12/7/5 

ME

12-07-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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# Picklist Print

Tuesday, July 03, 2012 1:50:40 PM

Page 1

Work Order ID: 85776  
Parent Item: D4016-3  
Parent Item Name: Hinge Half, Lid

Start Date: 6/15/2012  
Start Qty: 18.00  
Required Date: 6/21/2012  
Required Qty: 18.00

Comments: I[PP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as per dwg REV.A DD  
10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000 304 bar 1.00 x 1.00		Purchased	No			100	f	34.0270	0.08	1.5157895			

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT050	34.027	
113290	1.047	
→ 121806	20.4	
122008	12.58	

1.52

ml 12/07/03

W/O:		WORK ORDER CHANGES					
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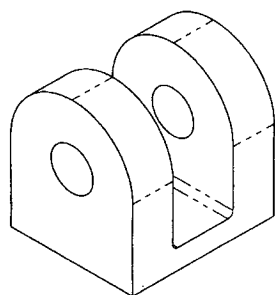
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

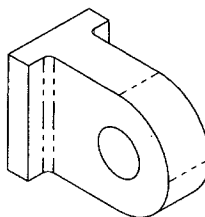
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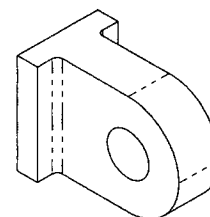




**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**



**D4016-5 HINGE HALF, LIGHT LID**

#85776  
**RELEASED**  
2010-02-16  
MP

A		NEW ISSUE		JPH		10.01.29	
REV.		DESCRIPTION			BY		DATE
DESIGN		AJS		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN		AJS					
CHECKED		GP		DRAWING NO.		REV.	
MFG. APPR.		SS		D4016		SHEET 1 OF 2	
APPROVED		MP		TITLE		SCALE	
DE APPR.		MP		BASKET HINGE		NTS	
DATE		10.01.29		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO REPRODUCTION OR DISSEMINATION OF THIS DOCUMENT IS TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

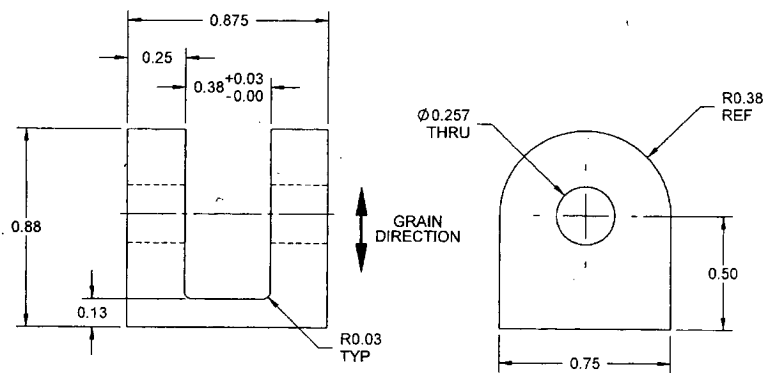
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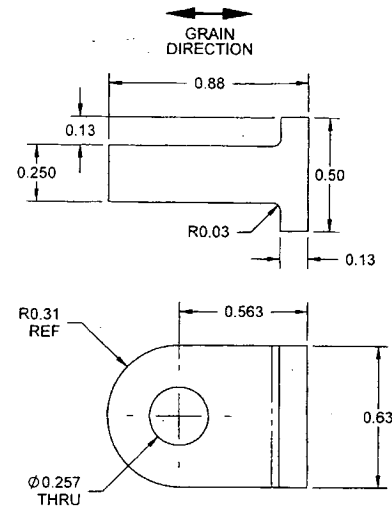
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**D4016-1 HINGE HALF, BASE**



**D4016-3 HINGE HALF, LID**

**D4016-5 HINGE HALF, LIGHT LID**

**NOTES:**

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs

**RELEASED**  
2010-02-16  
AM

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JP	DRAWING NO.	REV. A
MFG. APPR.	BS	D4016	SHEET 2 OF 2
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BASKET HINGE	NTS
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